

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013534**Date Inspected:** 16-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhao Chen Sun**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Components**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

**Tower Trial Assembly**

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW):

Weld joint # 021 located on West Tower Lift-1 Bearing stiffener WSD1 – SA294F/G. Welder is identified as 203269. ZPMC Quality Control (QC) Inspector is identified as Wang Chuangxin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2333 – Tc – P4 – F.

Weld joint # 051 located on base plate to shear plate WD1 – A28A/B between South and West shafts. Welder is identified as 040533. ZPMC Quality Control (QC) Inspector is identified as Fu Wei Min. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2332 – Tc – P5 – F.

Weld joint # 050 located on West Tower Lift-1 Bearing stiffener SSD1 – SA17F/G. Welder is identified as 054069. ZPMC Quality Control (QC) Inspector is identified as Wang Chuangxin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2333 – Tc – P4 – F.

Weld joint # 016 located on base plate to shear plate ND1 – A24A/B between North and East shafts. Welder is

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identified as 053116. ZPMC Quality Control (QC) Inspector is identified as Fu Wei Min. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2332 – Tc – P5 – F.

Weld joint # 005 located on West Tower Lift-1 Bearing stiffener WSD1 – SA294F/G. Welder is identified as 049541. ZPMC Quality Control (QC) Inspector is identified as Wang Chuangxin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2333 – Tc – P4 – F.  
(See attached photo)

Weld joint # 076 located on base plate to shear plate WD1 – A22A/B between South and West shafts. Welder is identified as 040533. ZPMC Quality Control (QC) Inspector is identified as Fu Wei Min. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2332 – Tc – P5 – F.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



### Summary of Conversations:

No Relevant Conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Skyler Guest - 15000422360, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Kumar,Sandeep	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford,William	QA Reviewer

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